

Date: Wednesday, 13/08/2008 10:55:31 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 90 DEGREE BLADE SUPPORT ASSY
Job Number	: 41214		
Estimate Number	: 13386		
P.O. Number	:	Part Number	: PB674300167
This Issue	: 13/08/2008 S.O. No. :	Drawing Number	: B6743001 PAGE24
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: B1
Previous Run	: 40243	Material	:
Written By	:	Due Date	: 15/09/2008 Qty: 6 Um: Each
Checked & Approved By	: <u>JUL 08 8.13</u>		
Comment	: Est Rev:A 08-06-19 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S090	6061-T6 .090 Sheet
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Comment: Qty.: 0.6241 sf(s)/Unit Total : 3.7447 sf(s)
6061-T6 .090 Sheet
batch: 108595 IB 8-9-3

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg B67-43001-147
Dwg Rev: B1 IB 8-9-3
Prog Rev: B1
2-Deburr if necessary IB 8-9-3



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

508/08/04 IB

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Form as per dwg B67-43001

IB 08/09/15



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 10:55:31 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 41214

Part Number: PB674300167

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

So 08/08/06

7.0

PB6743001149

Side Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Side Plate

34/231 = 10

324099 = 6

12 580092 17

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: Weld assembly as per dwg B67-43001

14.08.09.19

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08.09.24 (8)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

So 08/08/04 (8)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per CSI 005 4.1

008/09/24

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Nutplate

M 10 9068

08/09/24

14.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

RIVET

M 10 5978

08/09/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 41214

Part Number: PB674300167

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg B67-43001

8/08/09/24 (8)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/08/09/25 (8)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 246

8/9/05

(8x) 509

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30 (8)

Job Completion



MF 08-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

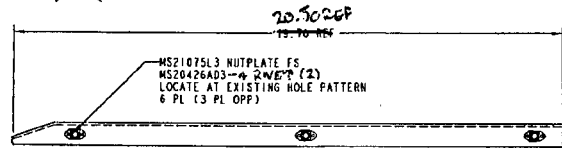
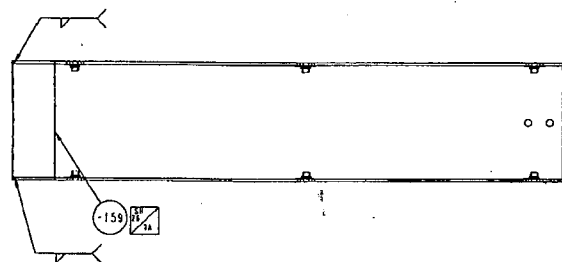
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

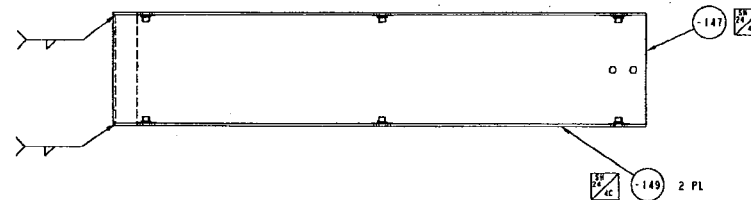
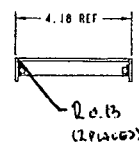
NOTE: Date & initial all entries

RELEASED



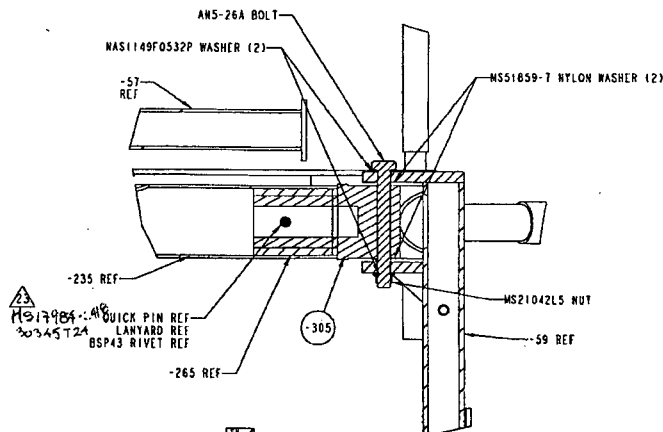
② -71 20 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500



② -67 90 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500



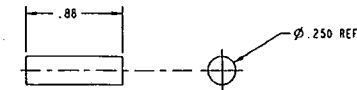
DETAIL A
SCALE 0.750
(-03 ASSY)

PREMIER AVIATION, INC.			
2000 Aviation Parkway, Grand Prairie, Texas 75052			
SIZE	CODE	REV	DATE
D	OSUV8	B67-43001	8/7
SCALE	WT	SHEET	9 of 45

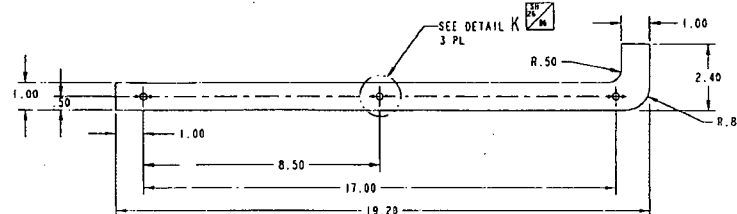
ORIGINAL

NO. 41214
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
150

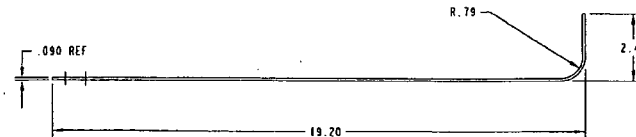
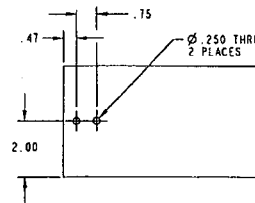
RELEASED
17 06 07 20



① -155 PIN
MATL: .250 RND, 303 SS
AMS5640 COND A
SCALE 2.000



④ -149 SIDE PLATE
MATL: .090 THK, 6061-T6, QQ-A-250/11
SCALE 0.500



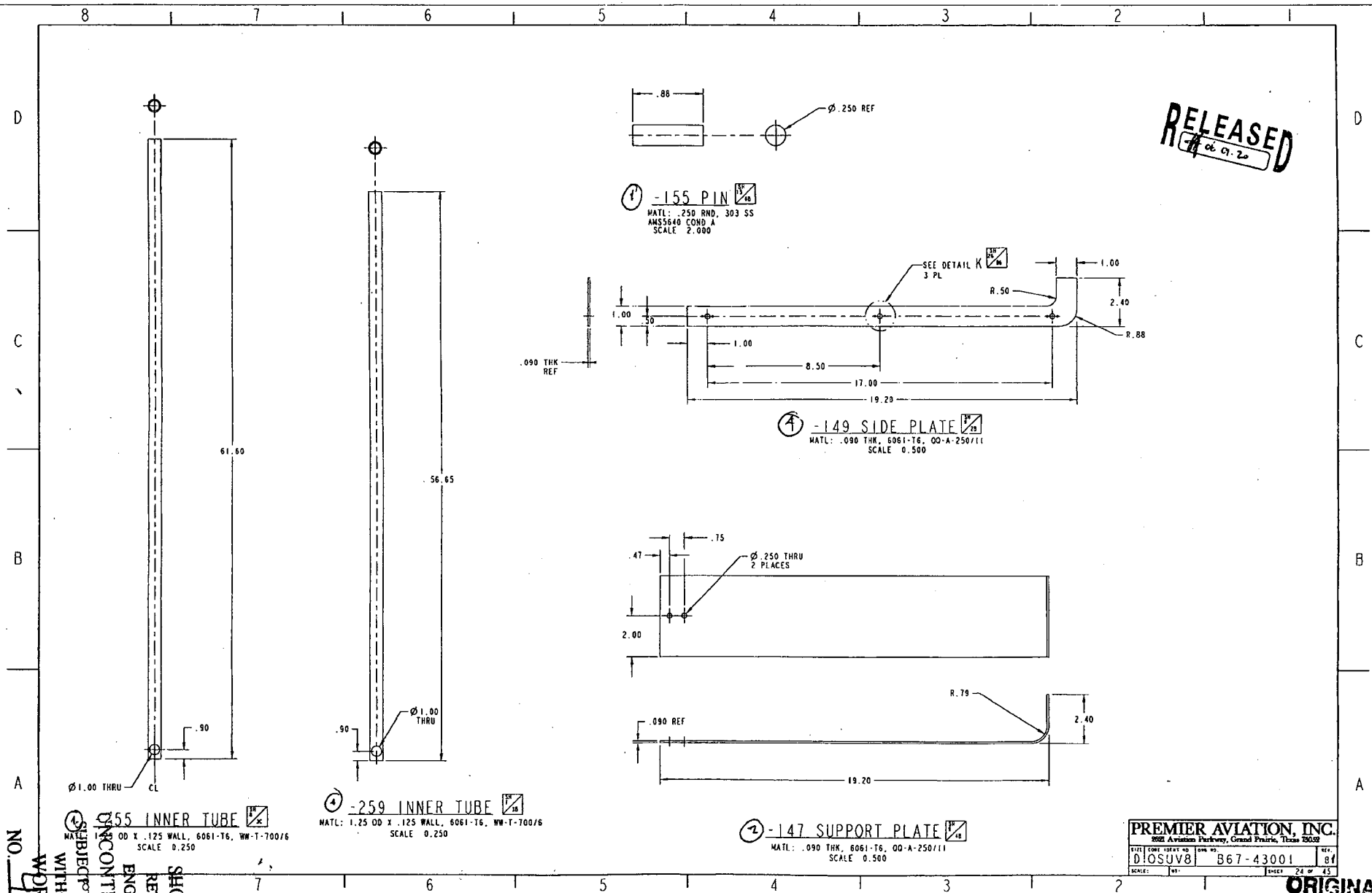
② -147 SUPPORT PLATE
MATL: .090 THK, 6061-T6, QQ-A-250/11
SCALE 0.500

④ -259 INNER TUBE
MATL: 1.25 OD X .125 WALL, 6061-T6, WW-T-700/6
SCALE 0.250

③ -155 INNER TUBE
MATL: 1.25 OD X .125 WALL, 6061-T6, WW-T-700/6
SCALE 0.250

PREMIER AVIATION, INC.
2002 Aviation Parkway, Grand Prairie, Texas 75052
REV. 81
D10SUV8 867-43001
SCALE: 10:1 SHEET 24 OF 45

ORIGINAL



NO. 41219
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

DART AEROSPACE LTD		Work Order:	41214
Description: 90° BLADE SUPPORT ASSY		Part Number:	PB 674 3001-147
Inspection Dwg: Rev: B1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	